

506-3

Instructions, complete

Operating Instructions

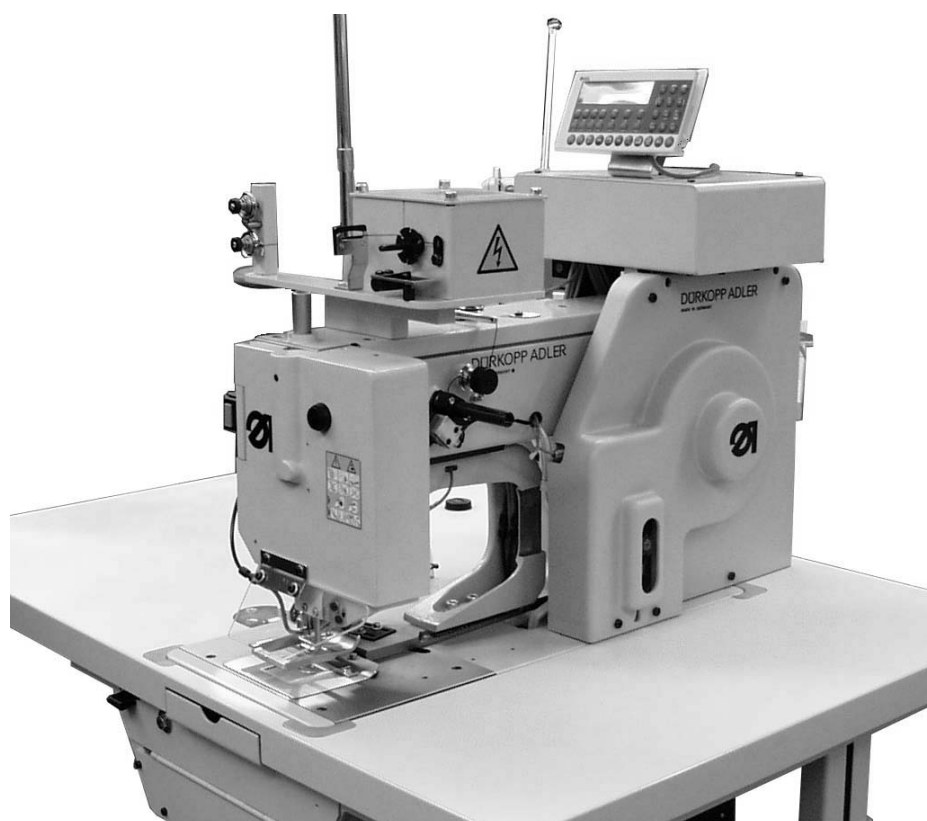
Installation Instructions

Service Instructions

1

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3



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Overview

Operating table

Operating Instructions
Installation Instructions
Service Instructions

Pneumatic circuit plan

9770 506002

Interconnection-diagram

9890 506003 B

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Foreword

This instruction manual is intended to help the user to become familiar with the machine and take advantage of its application possibilities in accordance with the recommendations.

The instruction manual contains important information on how to operate the machine securely, properly and economically. Observation of the instructions eliminates danger, reduces costs for repair and down-times, and increases the reliability and life of the machine.

The instruction manual is intended to complement existing national accident prevention and environment protection regulations.

The instruction manual must always be available at the machine/sewing unit.

The instruction manual must be read and applied by any person that is authorized to work on the machine/sewing unit. This means:

- Operation, including equipping, troubleshooting during the work cycle, removing of fabric waste,
- Service (maintenance, inspection, repair) and/or
- Transport.

The user also has to assure that only authorized personnel work on the machine.

The user is obliged to check the machine at least once per shift for apparent damages and to immediately report any changes (including the performance in service), which impair the safety.

The user company must ensure that the machine is only operated in perfect working order.

Never remove or disable any safety devices.

If safety devices need to be removed for equipping, repairing or maintaining, the safety devices must be remounted directly after completion of the maintenance and repair work.

Unauthorized modification of the machine rules out liability of the manufacturer for damage resulting from this.

Observe all safety and danger recommendations on the machine/unit! The yellow-and-black striped surfaces designate permanent danger areas, eg danger of squashing, cutting, shearing or collision.

Besides the recommendations in this instruction manual also observe the general safety and accident prevention regulations!

General safety instructions

The non-observance of the following safety instructions can cause bodily injuries or damages to the machine.

1. The machine must only be commissioned in full knowledge of the instruction book and operated by persons with appropriate training.
2. Before putting into service also read the safety rules and instructions of the motor supplier.
3. The machine must be used only for the purpose intended. Use of the machine without the safety devices is not permitted. Observe all the relevant safety regulations.
4. When gauge parts are exchanged (e.g. needle, presser foot, needle plate, feed dog and bobbin) when threading, when the workplace is left, and during service work, the machine must be disconnected from the mains by switching off the master switch or disconnecting the mains plug.
5. Daily servicing work must be carried out only by appropriately trained persons.
6. Repairs, conversion and special maintenance work must only be carried out by technicians or persons with appropriate training.
7. For service or repair work on pneumatic systems, disconnect the machine from the compressed air supply system (max. 7-10 bar). Before disconnecting, reduce the pressure of the maintenance unit. Exceptions to this are only adjustments and functions checks made by appropriately trained technicians.
8. Work on the electrical equipment must be carried out only by electricians or appropriately trained persons.
9. Work on parts and systems under electric current is not permitted, except as specified in regulations DIN VDE 0105.
10. Conversion or changes to the machine must be authorized by us and made only in adherence to all safety regulations.
11. For repairs, only replacement parts approved by us must be used.
12. Commissioning of the sewing head is prohibited until such time as the entire sewing unit is found to comply with EC directives.
13. The line cord should be equipped with a country-specific mains plug. This work must be carried out by appropriately trained technicians (see paragraph 8).



It is absolutely necessary to respect the safety instructions marked by these signs.

Danger of bodily injuries !

Please note also the general safety instructions.



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1. Scope of Delivery

- Frame with sewing drive and table 1100 x 736 mm
- Sewing machine with integrated bobbin winder
- Quick control unit
- Compressed air maintenance unit
- Yarn stand
- Foot switches
- Sewing light
- Tools and small parts in the accessories pack

2. Installation of the Unit



ATTENTION !

The unit may only be set up by trained personnel.
Before installing the unit it is essential that all transport fastenings be removed!

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2.1 Transport

For in-house transport lift the unit and transport on a suitable wagon (e.g. lift truck).

2.2 Setting the Work Height

The work height can be set between 76 cm and 106 cm (measured to the upper edge of the table).

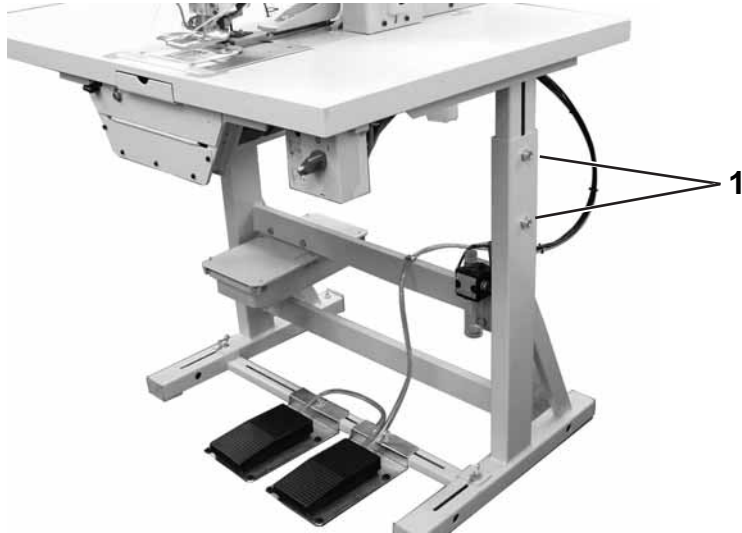
The unit is set at a work height of 82 cm at the factory.



Caution: danger of injury

The automatic sewing machine is very heavy. Once the screws have been removed the table top may fall at high speed.

When adjusting the working height it is essential to use auxiliary equipment such as trestles, lifting tackle and the like.

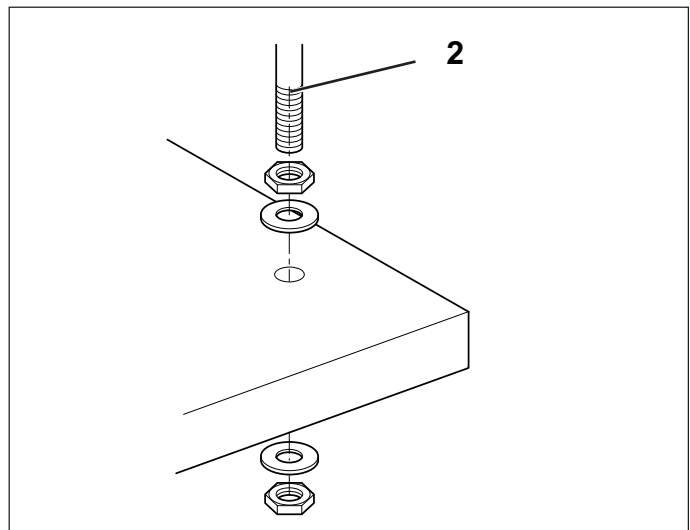


- Loosen the locking screws 1 on both sides of the frame.
- Set the base plate horizontally at the desired work height.
In order to avoid a tilt pull out or push in the base plate uniformly on both sides.
- Tighten the locking screws 1.

2.3 Attaching the Yarn Stand



2



- Insert the yarn stand 2 into the appropriate hole in the table and attach with the nuts and washers.

3. Electrical Connection



ATTENTION !

All work on the electrical components of the sewing unit may be carried out only by electricians or appropriately trained personnel.

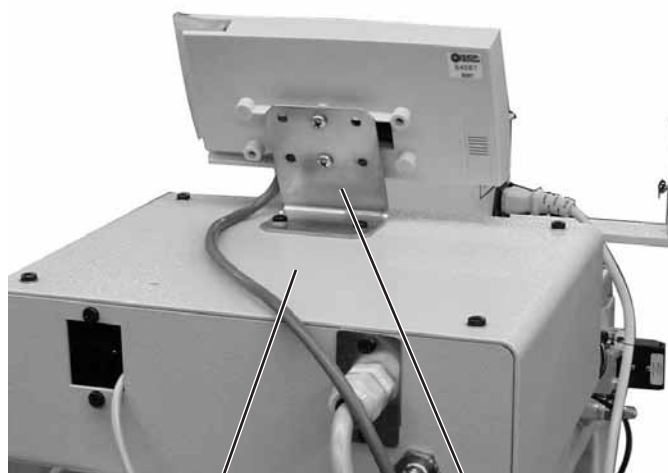
The mains plug must be pulled.

The instruction manual of the drive's manufacturer must imperatively be respected!

3.1 Connecting the Control Unit



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- Screw the operating panel 1 together with its bracket 2 onto the control unit 3.

4. Pneumatic Connection

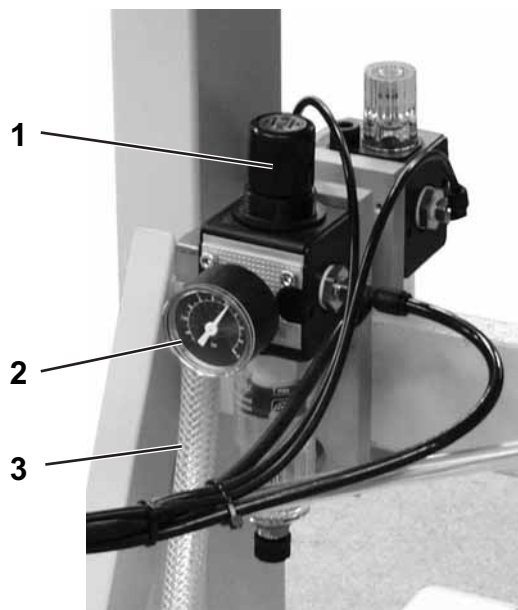
For the operation of the clamp lifting, thread tension opening, needle cooling, etc. the unit must be supplied with water-free compressed air.



ATTENTION !

For a flawless functioning of the pneumatic control processes the compressed air supply must be laid out as follows:

Even at the instant of greatest air consumption the minimum operating pressure may not fall below **5 bar**.



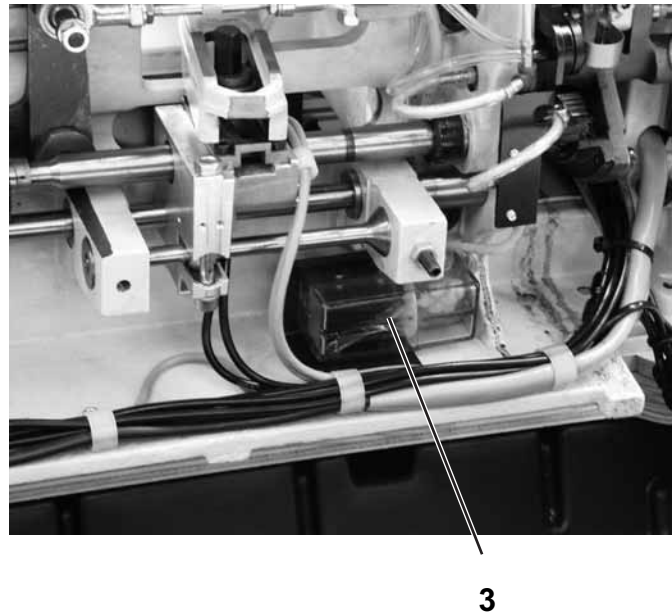
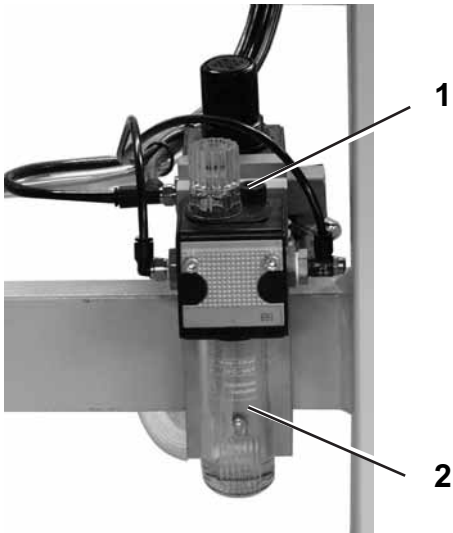
Connecting the compressed air maintenance unit

- Connect the connection hose 3 for the maintenance unit to the compressed air supply with the enclosed coupling.

Setting the operating pressure

- The operating pressure is **6 bar**.
It can be seen on the pressure gauge 2.
- For setting the operating pressure pull knob 1 up and turn.
 - Turning clockwise = Increase pressure
 - Turning counterclockwise = Decrease pressure

5. Oil supply



2

Filling the oil reservoir for shuttle-track lubrication

Only **DA-10** lubricating oil may be used to fill the oil reservoir.

DA-10 is available from **DÜRKOPP ADLER AG** retail outlets.

- Unscrew oil-filler cap 1.
- Fill the oil reservoir 2 with **DA-10** lubricating oil to the upper edge of the embossed text.

Checking the oil lever in the central recirculating-lubrication unit

Only **DA-10** lubricating oil may be used to fill the oil reservoir.

DA-10 is available from **DÜRKOPP ADLER AG** retail outlets.

- Fill the oil reservoir 3 with **DA-10** lubricating oil to the “max.” mark.

Notes: